

Shp June 15

Work Order ID 84699

84699

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May-22-12 1:03:10 PM

Item ID: D4464-041
Revision ID:
Item Name: Fuel Tank Assembly

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Start Date: 22/05/2012 Start Qty: 1.00 *1*
Required Date: 05/06/2012 Req'd Qty: 1.00 *1*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4464	D								

100 Weld per dwg A/R Aluminum rod Batch: 11918 0.00

100

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

1 0 12.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	BE12/05/30	
120 *120* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 120354 Memo 1-Weld top D4463-1 ***PURGE INSIDE OF TANK***	0.00 0.00				1	0		ll
123 *123* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***Pressure Test as per dwg D4464*** Water + helium Pump test only	0.00 0.00				8 blocks			te

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	8E12/06/05	
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo 1- brush alodine on tank. No alodine inside	0.00 0.00				1X	0	MD 2/06/05	
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				1	0	12-06-05	

W/O:		WORK ORDER CHANGES					
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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	***Mask prior to powdercoat***								
	POWDER COAT ANSI 61 GREY AS PER DWG AND QSI 005 4.3								
	Start Time: 9:10								
	Oven Temperature: 320°F								
	Finish Time: 9:40								
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

M118533

IX ~~Ø~~ M-L 12/06/06

IX ~~Ø~~ M 11/06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Small Fab Small Fab	<u>Pick hit</u> Memo 1- Mask off area, where access cover is applied 2- Abrade surface with red scotch brite 3- Wipe with clean cloth and wash and wipe 4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890 A/R proseal 890 Batch: <u>M121710</u>	0.00 0.00				1		12/04/06 JB	
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1x			12/06/08

Tested with Water and Air
at 4.5 psi

12-06-07

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: _____	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

Handwritten signature

MLJ 12/06/08

MF 12-06-08

PPP 84699

W/O:		WORK ORDER CHANGES					
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Work Order ID: 84699

84699

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5 *D3997-5* Placard		Manufactured	No			190	Each	12.0000	2	2	✓		
									**			JB 12/06/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				102					
				72611				82					
				81028				8					
				83650				12		83650			
D3997-11 *D3997-11* Placard		Manufactured	No			190	Each	13.0000	1	1	✓		
									**			JB 12/06/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				13					
				80308				1		80308			
				82957				12					
D3997-17 *D3997-17* Placard		Manufactured	No			190	Each	15.0000	1	1	✓		
									**			JB 12/06/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST141				15					
				80309				4		80309			
				82958				11					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84699

84699

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-29

Manufactured No

190

Each

16.0000

1

1

JB

12/06/06

D3997-29

Placard

Location

Loc Qty

Loc Code

ST141

16

80845

16

80845

D3997-43

Manufactured No

190

Each

13.0000

1

1

JB

12/06/06

D3997-43

Placard

Location

Loc Qty

Loc Code

ST141

13

80310

1

80310

82960

12

D3999-7

Manufactured No

100

Each

7.0000

1

1

12.05.30

D3999-7

Corner

Location

Loc Qty

Loc Code

WA014

7

71695

1

75156

6

1

D3999-9

Manufactured No

100

Each

6.0000

1

1

12.05.29

D3999-9

Angle

Location

Loc Qty

Loc Code

WA014

6

71696

1

82545

5

1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84699

84699

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-11

Manufactured No

100

Each

20.0000

1

1

D3999-11

Earth Tab

**

12.05.30

Location

Loc Qty

Loc Code

WA

27

84161

19

WA013

-8

WA014

1

75180

1

D4000-1

Manufactured No

100

Each

11.0000

1

1

D4000-1

Fuel Supply Fitting

**

12.05.30

Location

Loc Qty

Loc Code

WA

11

80029

1

83811

10

D4000-5

Manufactured No

100

Each

9.0000

1

1

D4000-5

Fuel Tank Vent Fitting

**

12.05.30

Location

Loc Qty

Loc Code

WA013

9

80030

1

83813

8

D4000-9

Manufactured No

100

Each

8.0000

3

3

D4000-9

Grommet

**

12.05.30

Location

Loc Qty

Loc Code

WA014

8

83814

8

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 84699

84699

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-045

Manufactured No

100

Each

5.0000

1

1

D4000-045

Fuel Pickup Fitting Assembly

**

12.05.30

Location

Loc Qty

Loc Code

WA

1

81071

1

WA013

3

72078

1

82696

2

WA014

1

71669

1

D4008-11

Manufactured No

100

Each

10.0000

1

1

D4008-11

Hinge Half

**

12.05.30

Location

Loc Qty

Loc Code

WA

10

80037

2

80838

8

D4008-041

Manufactured No

190

Each

1.0000

1

1

D4008-041

Fuel Filler Splash Guard Assembly

**

12/06/08

Location

Loc Qty

Loc Code

ST142

1

78910

1

B84013 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4023-3

Manufactured No

190

Each

8.0000

1

1

D4023-3

Cap and Flange

**

12.05.30

Location

Loc Qty

Loc Code

ST084

6

81898

6

ST110

1

73514

1

WA

1

80032

1

D4025-5

Manufactured No

190

Each

6.0000

1

1

D4025-5

Fuel Quantity Sender

**

JB 12/06/06

Location

Loc Qty

Loc Code

ST141a

6

76894

2

81899

4

81899

D4057-1

Manufactured No

100

Each

30.0000

3

3

D4057-1

Retaining Ring

**

12.05.30

Location

Loc Qty

Loc Code

WA013

30

71166

3

81889

3

83656

24

3

D4062-041

Manufactured No

190

Each

0.0000

1

1

D4062-041

Tank Support Assembly

**

384362 = 1

12.06.04

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Dart Aerospace Ltd

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4124-1

Manufactured No

100

Each

29.0000

4

4

D4124-1

Tab

**

12.06.04

Location

Loc Qty

Loc Code

WA

29

76895

7

83824

22

4

D4125-1

Manufactured No

100

Each

5.0000

1

1

D4125-1

Sump

**

12.05.29

Location

Loc Qty

Loc Code

WA

5

81151

1

83825

4

1

D4125-3

Manufactured No

100

Each

5.0000

1

1

D4125-3

End

**

12.05.29

Location

Loc Qty

Loc Code

WA

5

81152

1

83826

4

1

D4404-3

Manufactured No

100

Each

3.0000

1

1

D4404-3

Cushion, Side

**

JB 12/06/06

Location

Loc Qty

Loc Code

ST242A

3

76898

3

76898

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Dart Aerospace Ltd

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D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4404-5 Manufactured No

100 Each

1.0000

4

4

D4404-5

Cushion, Fwd

**

Location

Loc Qty

Loc Code

ST242A

1

76899

1

D4462-1 Manufactured No

100 Each

4.0000

1

1

D4462-1

Baffle

**

Location

Loc Qty

Loc Code

WA

4

83827

4

D4462-3 Manufactured No

100 Each

2.0000

1

1

D4462-3

Baffle

**

Location

Loc Qty

Loc Code

WA

2

83828

2

D4463-041 Manufactured No

120 Each

0.0000

1

1

D4463-041

Tank Top Assembly

D4463-3

Manufactured No

100 Each

2.0000

1

1

D4463-3

Tank Aft End

**

Location

Loc Qty

Loc Code

WA

2

83833

2

ES 12/06/07
B85349 (4)

12.05.29

12.05.29

12.05.30

12.05.30

B 84826 = 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4463-5

Manufactured No

100

Each

10.0000

1

1

D4463-5

Tank Upper Cut Out

**

12.05.30

Location

Loc Qty

Loc Code

WA

10

83834

10

D4463-7

Manufactured No

100

Each

2.0000

1

1

D4463-7

Tank Fwd End

**

12.05.30

Location

Loc Qty

Loc Code

WA001

2

83836

2

D4463-9

Manufactured No

100

Each

2.0000

1

1

D4463-9

Tank Back

**

12.05.29

Location

Loc Qty

Loc Code

WA001

2

83837

2

D4463-11

Manufactured No

100

Each

0.0000

1

1

D4463-11

Tank Front

**

12.05.29

D4463-13

Manufactured No

190

Each

5.0000

1

1

D4463-13

Tank Bottom

**

12.05.29

Location

Loc Qty

Loc Code

WA

5

82237

2

83831

3

May-22-12 1:03:16 PM

Shop Packet Print

Page 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 84699

84699

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3H5A Purchased No

190 Each 37.0000 5 5 ✓

AN3H5A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST351

37

118112

1

120693

36

120693

MS21042L3 Purchased No

190 Each 2,496.000 4 4 ✓

MS21042L3

Nut

**

JB

Location

Loc Qty

Loc Code

ST300

2496

117885

32

119017

1076

119075

138

121349

345

121444

905

121349

MS35206-266 Purchased No

190 Each 96.0000 4 4 ✓

MS35206-266

Screw

**

JB 12/06/06

Location

Loc Qty

Loc Code

ST294

96

119850

96

119850

1120693
4K

NAS 1149 DO332 J

M119717

12.06.07
52

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 84699

84699

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

190

Each

2,553.000

37

37

**

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST298

2553

117601

61

118077

1

118612

18

119537

33

120142

41

120308

17

120644

122

121243

760

121524

1500

121524

AN3-4A

Purchased

No

190

Each

654.0000

24

24

**

AN3-4A

Bolt

Location

Loc Qty

Loc Code

ST350

654

102832

88

104291

4

104625

184

117317

98

120308

80

120770

200

104625

D4577-1

Manufactured

No

190

Each

1.0000

1

1

**

D4577-1

Rear Access Panel

Location

Loc Qty

Loc Code

ST237A

1

83839

1

83839

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Page 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 84699

84699

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4577-3

Manufactured No

190

Each

1.0000

1

1

D4577-3

Middle Access Panel

**

JB

Location

Loc Qty

Loc Code

ST237A

1

83840

1

83840

D4577-041

Manufactured No

190

Each

1.0000

1

1

D4577-041

Fwd Access Panel Assembly

**

4577 JB

12/06/06

Location

Loc Qty

Loc Code

ST237A

1

83838

1

83838

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	MS35207-266	SCREW
41	37	NAS1149D0363J	WASHER

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84699 MLC
12/05/22

RELEASED
2012-05-09
JMS

D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS. ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D4464	SHEET 1 OF 5
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DE APPR.	BC	TANK ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Dart Aerospace Ltd

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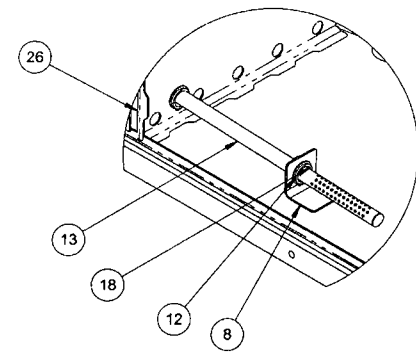
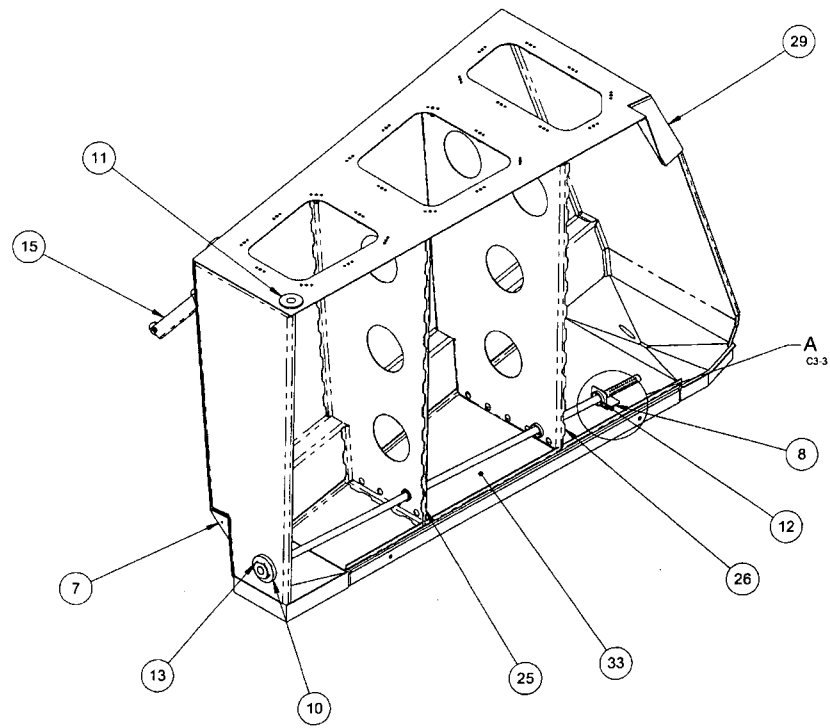
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NOTE: Date & initial all entries

84694



DETAIL A
ROTATED FOR CLARITY
SCALE 2X
B6-3

D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

RELEASED
2012-05-09
WJ

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D4464	SHEET 3 OF 5
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DE APPR.	JS	TANK ASSEMBLY	NTS
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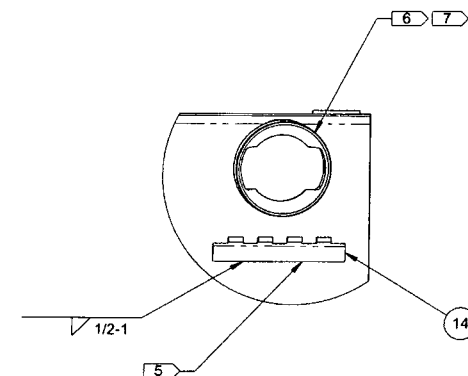
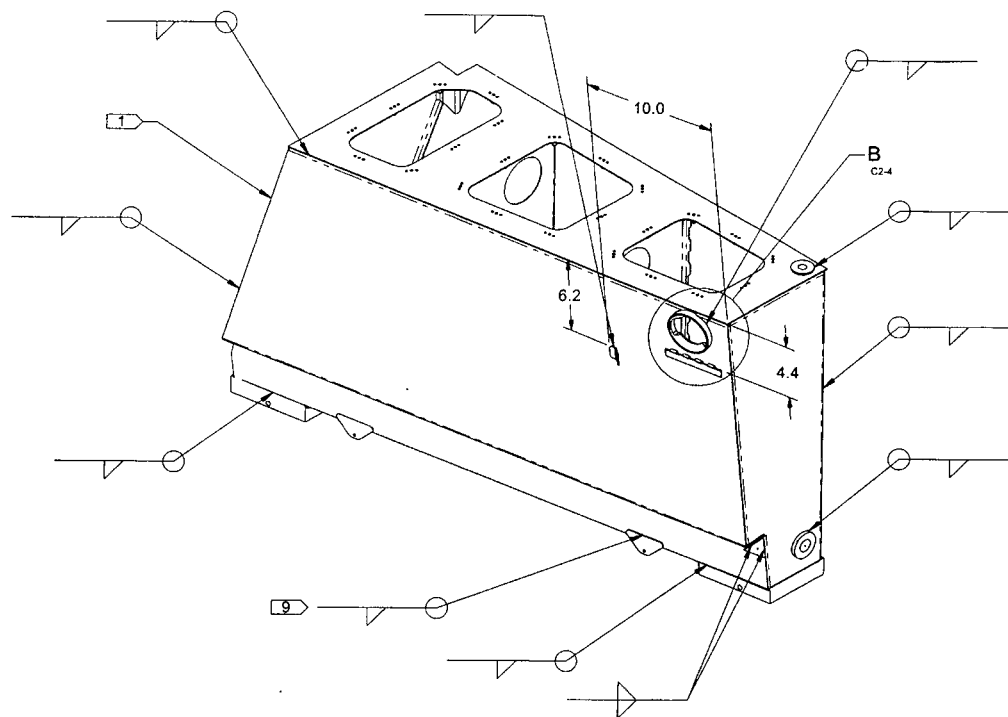
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

RELEASED
2012-05-09

D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
- END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
- ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING:
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING.



DESIGN	<i>SC</i>	DART AEROSPACE LTD	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>SC</i>	D4464	SHEET 4 OF 5
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	TANK ASSEMBLY	NTS
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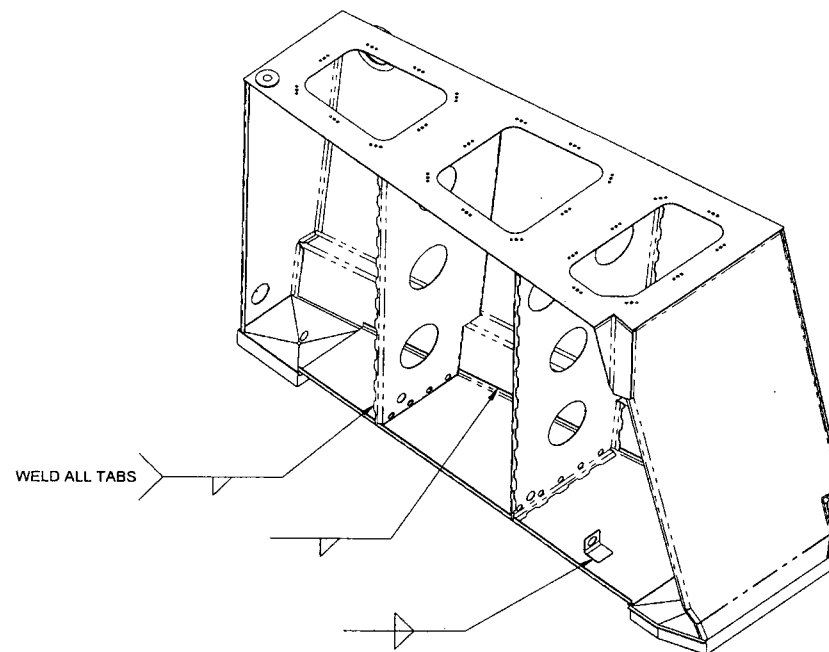
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NOTE: Date & initial all entries

84679



**D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

RELEASED
2012-05-09
MK

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
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